

Work Order ID 71221

Friday, June 24, 2011 11:17:42 AM

Page 1

Item ID: D2957

Accept

Revision ID:

Item Name: Mounting Plate

Start Date: 6/24/2011 Start Qty: 8.00

Required Date: 6/30/2011 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan: *H*Date: *11/06/24*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2957

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 10.500" long
1 blank makes 5 parts*cut 11/06/30**10**P*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA042
Deburr*cut 11/07/05**10**P*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*cut 11/07/05**10**P*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: *POTD*

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

JB (107) 11/07/06

11/7/06 JF
MF 11-07-06

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Picklist Print

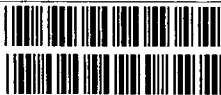
Friday, June 24, 2011 11:17:48 AM

Page 1

Work Order ID: 71221

Parent Item: D2957

Parent Item Name: Mounting Plate



Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C000.08.09 New dwg rev B (mpp 2078) EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X01.25 0		Purchased	No			100	f	13.6500	0.175	1.473684			



6061-T6 Bar .500 x 1.25

Location

Loc Qty

Loc Code

MAT010

13.65

103019

6.75

7872

6.9

1.48 on 14/06/10

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DART AEROSPACE LTD		Work Order:	71221
Description: Mounting Plate		Part Number:	D2957
Inspection Dwg: D2957 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	250	—		Vern 916-7	
0.068	+/-0.010	065	—		" "	
Ø0.323	+/-0.010	Ø.323	—		" "	
0.250	+/-0.010	250	—		" "	
1.06	+/-0.030	1.065	—		" "	
0.875	+/-0.010	.871	—		" "	
0.449	+/-0.010	.449	—		" "	
R0.12	+/-0.030	R.120	—		R-G	
1.85	+/-0.030	1.850	—		Vern 916-7	
0.250	+/-0.010	.252	—		" "	
0.19	+/-0.030	.190	—		" "	
0.125	+/-0.010	.125	—		" "	

Measured by:	mf	Audited by:	M.A	Prototype Approval:	N/A
Date:	11/07/05	Date:	11/07/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	HT

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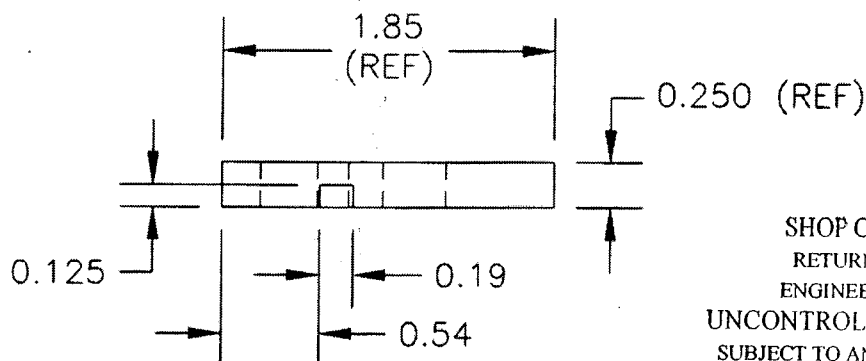
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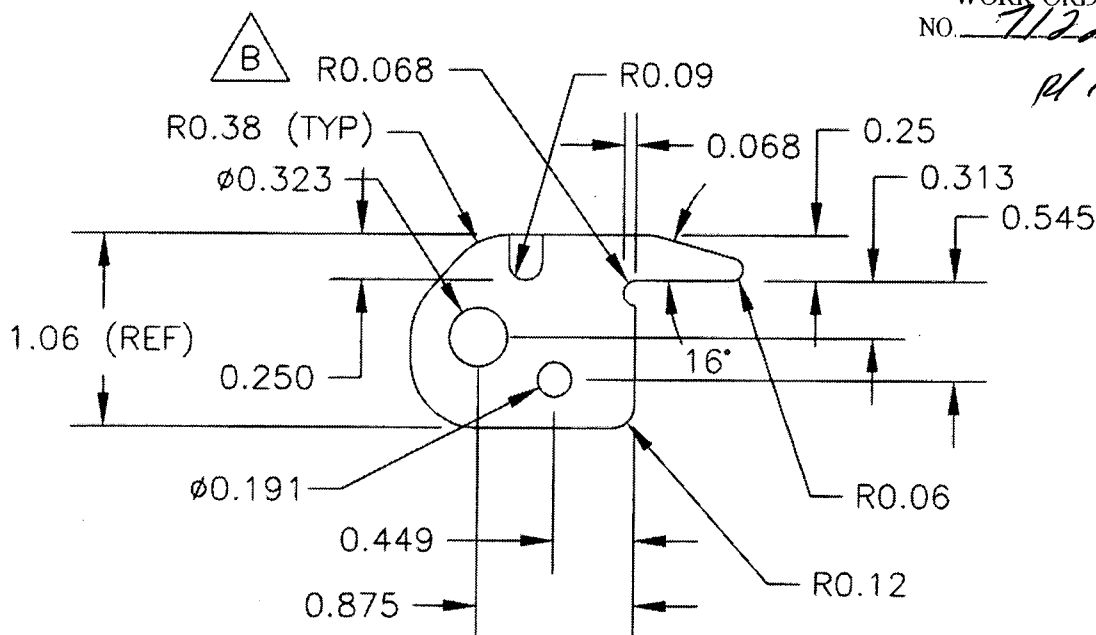
DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2957	REV. B SHEET 1 OF 1
DATE 00.07.06		TITLE MOUNTING PLATE	SCALE 1:1
A	00.01.20	NEW ISSUE	
B	00.07.06	MODIFY CORNER DETAIL	

RELEASED
00.07.10 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71221

PL 11-09-24



MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR
QQ-A-250/11) 0.250 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

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Dart Aerospace Ltd

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